

Work Order ID 145075

145075

Page 1

Tuesday, May 03, 2016 9:28:31 AM

Item ID: D4686-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Spacer

Start Date: 5/4/2016 Start Qty: 36.00 ***100*** Cust Item ID:
 Required Date: 5/6/2016 Req'd Qty: 36.00 ***100*** Customer:

Reference:

Approvals: Process Plan: SHA 20160503 Run Start ***NR1***
 QC: _____ Date: _____ Tooling: _____ Date: _____ Stop ***NR2***
 SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4686	B								
100	Hardinge CNC LATHE SMALL	0.00							
100									
Hardinge	Memo	0.00							
Hardinge CNC Lathe Small	Machine as per Folio FB164								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

DAS
45
9-89
20165-3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																								
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																							
Root Cause		FAULT CATEGORY																																																													
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	No Re-verification ☐	Operator ☐	Offset/Setup ☐	Supplier ☐	Training ☐	Use for Testing ☐	Poor Information ☐	Rushing ☐	Product Improvement ☐	Process Improvement ☐	Manufacturing Process ☐	Past Due ☐	Pressure/Forced ☐	Bending ☐	Centre Not Concentric ☐	Cracks ☐	Crimp/Kink/Ripple/Wave ☐	Cuffs ☐	Crushing ☐	Heat Treat ☐	Wave/Twist in Tube ☐	Marks/Chatter ☐	Temperature/Cure ☐	Set-up ☐	BOM/Route ☐	Broken/Damage/Defect ☐	Inspection Incomplete/Unqualified ☐	Contamination ☐	Countersink ☐	Cut Too Short ☐	Instructions Incomplete/Unclear ☐	Drill Holes ☐	Power Loss/Surge ☐	Folio/Program ☐	Grain ☐	Weld ☐	Wrong Stock Pulled ☐	Out of Sequence ☐	Off-set ☐	Mislabeled ☐	Fit/Function ☐	Misaligned/off center ☐	Positioned Wrong ☐	Outside Dimensions ☐	Over/Under tolerance ☐	Part Incorrect ☐	Part Lost/Missing ☐	Part Moved ☐	Drawing ☐	Finish ☐	Misread ☐	Turning Sequence ☐
																								OTHER : _____																																							

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Tuesday, May 03, 2016 9:28:32 AM

145075

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Item ID: D4686-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 5/4/2016 Start Qty: 36.00 ***36*** Cust Item ID:
Required Date: 5/6/2016 Req'd Qty: 36.00 ***36*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
122	Outsource process - Heat Treat	0.00							
122									
Outsource1	Memo	0.00							
Outsource process - Heat Treat	ISSUE P/O: <u>32238</u> To be heat treat to T4 condition as per dwg ENSURE C OF C IS ATTACH								
124	Receive & Inspect for Damage & Mat'l Certs	0.00							
124									
Packaging	Memo	0.00							
Packaging	ENSURE C OF C IS ATTACH								
126	QC6- Inspect dimensions to drawing	0.00							
126									
QC	Memo	0.00							
Quality Control									

104 MAY 04 2016 DAS 13 9-89
104x SP16-05-27
104 DAS 38 9-89 MAY 27 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																									
Description Work Order Deviation				Disposition																																																													
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																

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Item ID: D4686-1

Accept

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Stop ***NS2***

Item Name: Spacer

Start Date: 5/4/2016 Start Qty: 36.00

36

Cust Item ID:

Required Date: 5/6/2016 Req'd Qty: 36.00

36

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Chemical Conversion Coat per QSI005 4.1	0.00				104		16-6-1	
130									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00				104		16-06-01	
140									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location <u>16001</u>	0.00				104		16-6-1	
150									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL** LOCATION: LG001								

DAS
18
9-89DAS
18
9-89DAS
19
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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Revision ID: Stop ***NS2***
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Start Date: 5/4/2016 Start Qty: 36.00 ***36*** Cust Item ID:
Required Date: 5/6/2016 Req'd Qty: 36.00 ***36*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

_____ **JUN 01 2016**

_____ **JUN 01 2016**

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QS1042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ -Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Picklist Print

Tuesday, May 03, 2016 9:28:38 AM

Page 1
1

Work Order ID: 145075

145075

Parent Item: D4686-1

D4686-1

Parent Item Name: Spacer

Start Date: 5/4/2016

Required Date: 5/6/2016

Start Qty: 36.00

Required Qty: 36.00

Comments: IPP REV:A 13.02.20 NEW ISSUE DD VERF:JLM IPP
REV:B 13-06-15 NEW LENGHT JLM VERIFIED BY:DD IPP REV:C
13.11.14 AS PER DWG REV.B DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.750W.058		Purchased	No			100	f	182.8000	0.44	16.67368			

M6061T6T0 750W 058

6061-T6 RD Tube .750 x.058W

16/05/03

Location	Loc Qty	Loc Code
GA	3	
112652	3	
MAT015	179.8	
m127067	179.8	

48'

DQA: _____ Date: _____

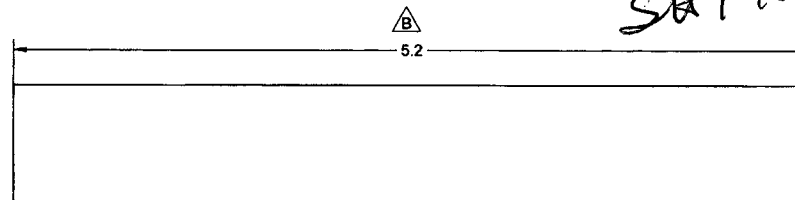
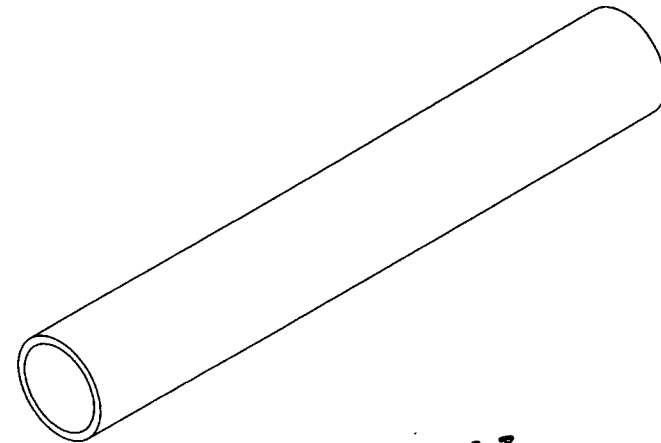
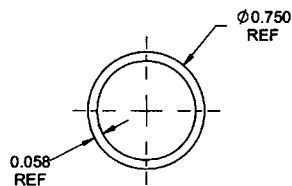


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							



20160503
SH 145075

D4686-1 SPACER

RECEIVED
13.08.13

- NOTES:**
- 1) MATERIAL: 6061-T4/T42 SEAMLESS ALUMINUM TUBING Ø0.750 X 0.058 WALL PER WW-T-700/6, AMS 4081 OR ASTM B210 (REF. DART SPEC M6061T4T0.750W.058)
OR
6061-T6/T62 ALUMINUM TUBING PER WW-T-700/6, AMS 4080 / 4082, OR ASTM B210 (REF DART SPEC M6061T6T0.750W.058)
HEAT TREAT TO -T4/T42 CONDITION. MIN UTS = 30 KSI (60 HREW MIN)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.7
 - 7) WEIGHT: 0.06 lbs

B	SPACER LENGTH INCREASED BY 1.5 IN TO ACCOMMODATE SWAGING TOOL. LENGTH TOLERANCE CHANGED	AP	13.08.08
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AS	DRAWING NO.	REV. B
MFG. APPR.	AS	D4686	SHEET 1 OF 1
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	SPACER	NTS
DATE	13.08.08	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32238**

Purchase Order Date 5/3/2016

PO Print Date 5/3/2016

Page Number 1 of 2

Order From :

VC-ATB001

AGGRESSIVE TUBE BENDING
9750 - 188TH STREET
SURREY, B.C. V4N 3M2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED

MAY 09 2016

Contact Name

Vendor Phone 604-882-4872

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

Terms

Currency

FOB

10127-2607

Net 30

CAD

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	145050	D5304-1 CROSSBOLT SPACER	5/9/2016 Yes 5/9/2016		34.00	\$1.53	\$52.01

HEAT TREAT TO T4/T42 CONDITION
MIN. UTS=30 KSI (60 HREW MIN)
NOTE: DETAIL C OF C REQUIRED

PART ARE MADE FROM 6061-T6 MATERIAL

Line Total: \$52.01

2	145075	D4686-1 SPACER	5/9/2016 Yes 5/9/2016		100.00	\$1.53	\$152.99
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HEAT TREAT TO T4/T42 CONDITION
MIN. UTS=30 KSI (60 HREW MIN)
NOTE: DETAIL C OF C REQUIRED

PART ARE MADE FROM 6061-T6 MATERIAL

Line Total: \$152.99

Note:

5/3/2016

PYROTEK

0723742 BC LTD.

#101 2285 Queen St. Abbotsford BC Canada V2T
6J3 Phone : (604) 859-4484 Fax: (604) 859-4481
Email: pyrotek@pyrotek.com

Packing Slip

Number: 92877

Ship Date: May 25, 2016

Customer's PO #: 16-0596_1

Pyrotek's W/O #: 92791

Cert #: 92877

Aggressive Tube Bending Inc.**9750 - 188th Street
Surrey, BC V4N 3M2**

Phone: (604) 882-4872

Ship Via: PICK UP

Heat Treat Process : Solution Heat Treat to "W" Condition / Natural Age to 6061-T4 Temper

PO Line #	Qty	Part #	Description	Reference
1	✓ 34 ea.	N/A	ALUMINUM TUBES	USED BY 16-0596/1 OP #30
2	✓ 45 ea.	N/A	ALUMINUM TUBES	
3	✓ 59 ea.	N/A	ALUMINUM TUBES	

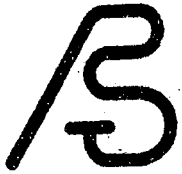
SP/16-05-27

Total: 138

Received By: _____

Date: May 25, 2016



**AGGRESSIVE TUBE BENDING INC.**

9750 188th Street
Surrey, BC V4N 3M2
Phone: 1-604-882-4872
Fax: 1-604-882-4873

PACKLIST

Packlist ID: 28336
Date: 2016-05-25
Page: 1 of 1

Shipped By:

Sold To Address	Ship To Address
DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 CANADA	DART AEROSPACE LTD 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 CANADA

CUSTOMER ID		CUSTOMER PO	PAYMENT TERMS		F.O.B.
2883		32238 ✓	Net 30		
SALES REP ID		SHIPPING METHOD		SHIP DATE	OUR ORDER NUMBER
YT		FEDEX 1-800-463-3339			16-0596
QUANTITY		CUSTOMER			
ORD	SHIP	BCK	PART ID	DESCRIPTION	PART NO. DRAWING #

34 ✓	ANNEAL 3/4 X .125 @ 5.200" ✓	D5304-1 ✓ B145050
45 ✓	ANNEAL 3/4 X .058 @ 5.200" ✓	D4686-1 ✓ B145075
59 ✓	ANNEAL 3/4 X .058 @ 5.200" ✓	D4686-1 B145075
1	QA/TESTING	

ORDER SPECIFICATIONS

SHIP FEDX ACCT# 151793240 P1 OVERNIGHT

8/6-05-27.

RECEIVED BY: _____

QA REQUIREMENTS: Mill Test Reports

CERTIFICATE OF CONFORMANCE

PYROTEK 0723742 B.C. LTD.

CUSTOMER P.O. # 16-0596_1

CERT: 92877

101 - 2285 Queen Street, Abbotsford, B.C. V2T 6J3

TEL: (604) 859-4484 FAX: (604) 859-4481

PYROTEK W.O. #: 92791

W.O. Date: 05/20/2016

CERT DATE: May, 25 2016

CUSTOMER: Aggressive Tube Bending Inc.

9750 - 188th Street, Surrey, BC V4N 3M2

MATERIAL: 6061-F

ALUMINUM TUBE

0.058" - 0.125" BARE

PROCESS DESCRIPTION: Solution Heat Treat to "W" Condition / Natural Age to 6061-T4 Temper

QUANTITY	PART NUMBER	PARTS DESCRIPTION	REFERENCE
34 ea.	N/A	ALUMINUM TUBES	USED BY 16-0596/1 OP #30
45 ea.	N/A	ALUMINUM TUBES	
59 ea.	N/A	ALUMINUM TUBES	

BATCH #	PROCESS	TIME	TEMPERATURE	FURNACE	SPECIFICATIONS
37653	Solution Heat Treat	0:58 Minutes	985 deg. F.	6	AMS 2770 Rev N
	Quench	7 Second	71/75 deg. F.		

Natural Age

Ambient

Glycol Quench 22 % max

Air Cool Ambient

TEMPER VERIFICATION REPORT

SPECIFICATION: AMS 2658 "C"

HARDNESS: 64.0 - 69.0 HR15TW

PYROTEK Certifies that the items listed hereon have been HEAT TREATED IN ACCORDANCE with the above LISTED SPECIFICATION, have been inspected and tested and conform to all Contract or Purchase Order requirements. TEMPER IS CERTIFIED for the Items in their Present State of Condition. Documentation is on file.

ELECTRICAL CONDUCTIVITY:

N/A % IACS

Accredited
NadcapTM
HEAT TREAT

QTY. ACCEPT

34+45+59

QTY. REJECT

0

MANAGER, QUALITY ASSURANCE

May 25, 2016

DATE